Drawing Name

Part Number

Material

Due Date

EC

Drawing Number

Project Number

Drawing Revision

: PILOT/CO-PILOT STEP, RH (FOLDING)

: D412-630 REV.J, P17 K PG. 19

: D412630032

: 7/31/2007

Wednesday, 7/11/2007 2:45:59 PM Kim Johnston -User **Process Sheet** Customer : CU-DAR001 Dart Helicopters Services Job Number : 33463 : 10824 **Estimate Number** : NA P.O. Number S.O. No. : NA : 7/11/2007 This Issue : NC Prsht Rev. NA : LARGE FAB ASSY First Issue Type : 32082 Previous Run Written By Checked & Approved By **NEW ISSUE** EC : EST. REV. A 05.11.21 Comment 05.12.19 updated pick list EST. REV. B **Additional Product** Job Number: < Description: Seq. #: **Machine Or Operation:** DOCUMENT CONTROL 1.0 Comment: DOCUMENT CONTROL Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG001 2.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per dwg D412-630 Step Weldment 3.0 D3463042

SMALL & MEDIUM FAB RESOURCE 1

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

Comment: Qty.: 1.0000 Each(s)/Unit

3.0000 Each(s) Total:

Pick: Qty

1

Pick:

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Part Number D3463-042

Description

Batch

Step weldment

D3443043 4.0

Comment: Qtv.:

Strut Weldment Assembly



1.0000 Each(s)/Unit 3.0000 Each(s) Total:

Qtv Part Number D3443-043

Description Strut ass'y

B 29672 x/mx, B 28524x/mx.

D3443041 5.0

Comment: Qty.:

Strut Weldment Assembly

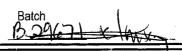


3.0000 Each(s) 1.0000 Each(s)/Unit Total:

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Part Number D3443-041

Description Strut ass'y





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Wednesday, 7/11/2007 2:45:59 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Job Number: 33463 Part Number: D412630032 Job Number: Description: Seq. #: **Machine Or Operation:** PIN D34439 6.0 Total: 6.0000 Each(s) Comment: Qty.: 2.0000 Each(s)/Unit Pick: Description Batch Qty Part Number 132228 D3443-9 2 Pin SS Bolt 7.0 AN4CH3 Comment: Qty.: 6.0000 Each(s) 2.0000 Each(s)/Unit Total: Pick: Description Part Number Qty m103248 2 AN4CH3 **BOLT** A/R MS20995c41e Lockwire BOLT AN4C14 8.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s) Pick: Description Batch Qty Part Number m103248 **BOLT** 1 AN4C14 9.0 D34547 Bushing Comment: Qty.: 2.0000 Each(s)/Unit 6.0000 Each(s) Total: Pick: Batch 30225 Qty Part Number Description 2 D3454-7 Bushing 07-07-26 NUT 10.0 AN3104 Comment: Qty.: Total: 3.0000 Each(s) 1.0000 Each(s)/Unit Pick: Description Batch 3641 Qty Part Number AN310-4 1 Nut

Dart Ae	rospace L	.td								
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Wednesday, 7/11/2007 2:45:59 PM Date: Kim Johnston User:` **Process Sheet** Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630032 Job Number: 33463 Job Number: Description: Seq. #: Machine Or Operation: MS24665227 **COTTER PIN** 11.0 Comment: Qty.: Total: 3.0000 Each(s) 1.0000 Each(s)/Unit Pick: Qty Part Number Description mio 2017 **COTTER PIN** MS24665-227 1 07-07-26 12.0 D34551 Spacer Comment: Qty.: 6.0000 Each(s) Total: 2.0000 Each(s)/Unit Pick: Part Number Description Batch Qty 1328171 D3455-1 Spacer 2 Washer 13.0 D34651 1.0000 Each(s)/Unit 3.0000 Each(s) Comment: Qty.: Total: Pick: Batch 30308 Description Qty Part Number Washer D3465-1 1 NUT 14.0 AN3107 Comment: Qty.: 3.0000 Each(s) 1.0000 Each(s)/Unit Total: Pick: Description Batch Qty Part Number m103286 1 AN310-7 Nut 01-07-26 15.0 MS24665302 Cotter Pin Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s) Pick: Description Part Number Qty m16941 **COTTER PIN** 1 MS24665-302 07-07-26

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Wednesday, 7/11/2007 2:45:59 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Job Number: 33463 Part Number: D412630032 Job Number: Description: Seq. #: Machine Or Operation: O CURRENT STEP INSPECT WORK 16.0 QC5 Comment: INSPECT WORK TO CURRENT STEP ****ensure tension to retract step is 11 to 18 lbs ** Test fit on aircraft in Eng. lab. PACKAGING RESOURCE #1 PACKAGING 1 17.0 Comment: PACKAGING RESOURCE #1 Pick Packing Kit D34541 Bushing 18.0 3.0000 Each(s) Comment: Qty.: Total: 1.0000 Each(s)/Unit Pick: -Qty Part Number Description Bushing D3454-1 1 D34543 Bushing 19.0 6.0000 Each(s Comment: Qty.: 2.0000 Each(s)/Unit Total: Pick: Qty Part Number Description Batch D3454-3 Bushing 2 20.0 D34545 Bushing Comment: Qty.: 6.0000 Each(s) 2.0000 Each(s)/Unit Total: Pick: Qty Part Number Description 2 D3454-5 Bushing 21.0 D34551 Spacer Comment: Qty.: 18.0000 Each(s) Total: 6.0000 Each(s)/Unit Pick: Batch 1528171 Description Qty Part Number D3455-1 Spacer 6

W/O:		WORK ORDER CH	HANGES				
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Part No	,•	PAR #: Fault Category:	NCR: Yes	No DO	Δ.	Date:	

QA: N/C Closed: ____ Date: _

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Wednesday, 7/11/2007 2:45:59 PM Date: User: Kim Johnston **Process Sheet** Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Job Number: 33463 Part Number: D412630032 Job Number: Description: Seq. #: Machine Or Operation: Spacer 22.0 D34553 Comment: Qty.: 6.0000 Each(s) 2.0000 Each(s)/Unit Total: Pick: Qty Part Number Description 2 D3455-3 Spacer D3462042 23.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s Pick: Description Qty Part Number Bracket ass'y 1 D3462-042 NUT 24.0 AN3104 Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s) Pick: Description Qty Part Number 2 AN310-4 Nut AN3105 25.0 Comment: Qty.: 6.0000 Each(s) 2.0000 Each(s)/Unit Total: Pick: Batch <u>M/U2_07</u>3 Description Qty Part Number 2 AN310-5 Nut Bolt 26.0 AN3C5A Comment: Qty.: 9.0000 Each(s) 3.0000 Each(s)/Unit Total: Pick: Description Qty Part Number AN3-C5A Bolt 3 27.0 AN44C12 Comment: Qty.: 3.0000 Each(s) Total: 1.0000 Each(s)/Unit Pick: Qty Part Number Description Batch

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Wednesday, 7/11/2007 2:45:59 PM Date: User: Kim Johnston **Process Sheet** Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Job Number: 33463 Part Number: D412630032 Job Number: Description: Seq. #: Machine Or Operation: AN44-C12 Eyebolt 1 BOLT 28.0 AN4C15 Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s) Pick: Description Part Number 1103248 Qty **BOLT** AN4C15 BOLT AN5C11 29.0 Comment: Qty.: 3.0000 Each(s) 1.0000 Each(s)/Unit Total: Pick: M103248 Qty Part Number Description⁻ **BOLT** AN5C11 1 **BOLT** 30.0 AN5C15 3.0000 Each(s) Total: Comment: Qtv.: 1.0000 Each(s)/Unit Pick: Batch 104395 Description Part Number Qty AN5C15 **BOLT** 1 WASHER 31.0 AN960C10 7.0000 EACH(s)/Unit Total: 21.0000 EACH(s) Comment: Qty.: Pick: Description Qty Part Number M101069 Washer AN960C10 WASHER 32.0 AN960C516 Comment: Qty.: 3.0000 Each(s) Total: 1,0000 Each(s)/Unit Pick: M17697 Description Qtv Part Number AN960C516 Washer 1

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Wednesday, 7/11/2007 2:46:00 PM Date: User: Kim Johnston **Process Sheet** Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Job Number: 33463 Part Number: D412630032 Job Number: Description: Seq. #: Machine Or Operation: Nut 33.0 MS210433 Total: 9.0000 Each(s) Comment: Qty.: 3.0000 Each(s)/Unit Pick: M104677 Part Number Description Qty MS21043-3 Nut MS24665227 **COTTER PIN** 34.0 Comment: Qty.: 6.0000 Each(s) 2.0000 Each(s)/Unit Total: Pick: Description Qty Part Number **COTTER PIN** 2 MS24665-227 COTTER PIN 35.0 MS24665229 Comment: Qty.: 6.0000 Each(s) 2.0000 Each(s)/Unit Total: Pick: Description Qty Part Number 2 MS24665-229 **COTTER PIN** 36.0 NAS1515H5 Comment: Qty.: 3.0000 Each(s) Total: 1.0000 Each(s)/Unit Pick: Description Qty Part Number Washer NAS1515H5 1 INSPECT 100% KITS FOR COMPLETENESS 37.0 QC4 Comment: INSPECT 100% KITS FOR COMPLETENESS 38.0 Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP 0412-630-031 Location: 30 PPP Rev:

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Date:

Wednesday, 7/11/2007 2:46:00 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 33463

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description:

39.0

QC21



FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



N P-87-30

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FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

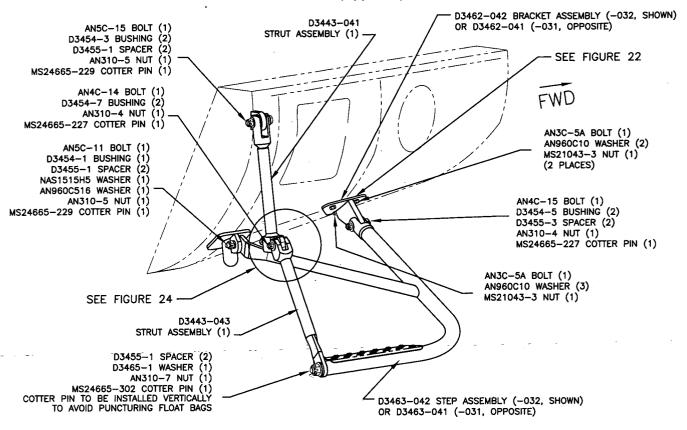
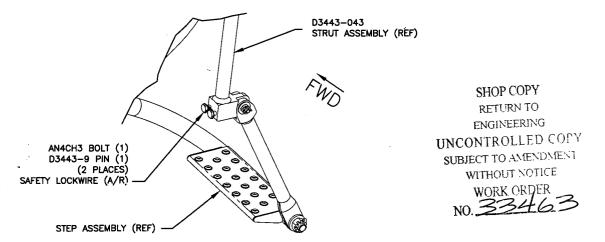


FIGURE 24 – Detail Safety Wiring, D412-630-032 RH,Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)



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Revision:

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Date: 06.10.05